



Dart Aerospace Ltd.
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Canada

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D3319-3**Job Sheet 198361****Part No:** D3319-3**Job Qty:** 10 pcs**Part Name:** Full Length Wearplate**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/25/19**Job Tracking No:****Due Date:** 10/28/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER
DWG REV.D DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup	Run				
					Hrs	Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	10 pcs		10/28/19	0.17	2.34	Waterjet - Flow	8/11/19	9:09	DAS
110	QC 2	10 pcs		10/28/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

**Container No:** S206515**Part:** D3319-3**Job No:** 198361**Serial No/Batch:** S206515**Revision:** D**Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 09/24/19

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120 QC 8	10 pcs	10/28/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	7/19/19
				QC 8 - 12	DAS 9-89
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	DAS
				QC 8 - 35	81
				QC 8 - 39	9-89
				QC 8 - 4	
				QC 8 - 44	AUG 19 2019
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	10 pcs	10/28/19	0.25 0.67	Small Fab - Brake - 1 - B4B	DAS 30
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
150 QC 5	10 pcs	10/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40
				QC 5 - 61	SEP 17 2019 9-89
				QC 5 - 81	
160 Automated Welding - B4B	10 pcs	10/28/19	0.00 3.19	Automated Welding - 1 - B4B	ML ✓
170 QC 10	10 pcs	10/28/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	

7/25/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 QC 5	10 pcs	10/28/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	02
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	02
				QC 5 - 30	
190 Spray Paint - 2 - B4B	10 pcs	10/28/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-9-25
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 3	10 pcs	10/28/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS
				QC 3 - 59	81
				QC 3 - 68	9-89
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
210 Packaging 3-1 - Stock - B4B	10 pcs	10/28/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	✓ ST 260B
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

Rosales, Oscar

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA		10 ✓ pcs	10/28/19	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53

ST 260B

DAS

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Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form using DT8326 & DT8261 as per Dwg D3319

150 - (QC5- Inspect part completeness to step on W/O)

160 - 8259 Hardcoat Rod M139018

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5213093

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	32.5000 sf (3.25 ea)	100-Waterjet - Flow - 1	<u>5148581</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	33	266	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		
12	Wearplate	8.690inches ± 0.010	8.700 8.680		
13	Wearplate	30.790inches ± 0.010	30.800 30.780		
14	Wearplate	52.880inches ± 0.030	52.910 52.850		
15	Wearplate	62.770inches ± 0.010	62.780 62.760		
16	Wearplate	74.420inches ± 0.010	74.430 74.410		
17	Wearplate	75.520inches ± 0.030	75.550 75.490		
18	Wearplate	0.050inches ± 0.010	0.060 0.040		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION Job: _____ Part No. _____ Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____	
Description Work Order Deviation		Disposition	
		MRB (QSI042)	
		Completed By	
		Lead hand / Supervisor	
QC / QA Coordinator			
FAULT CATEGORY			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:	
Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			